

**Work Order ID 56038**

Tuesday, February 09, 2010 11:41:17 AM



Page 1

Item ID: DSK076

Accept



Setup Start



Revision ID:

Item Name: D2891-1 TURNING DETAIL

Stop



Start Date: 2/10/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 2/23/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 0-2-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSK076	Rev A

100



DOOSAN LATHE

Doosan

Doosan Lathe

Memo

0.00

SJ 10/02/22

(10)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

SJ 10/02/22

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

S.F 10/02/22

10 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56038**

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Tuesday, February 09, 2010 11:41:17 AM

Item ID: DSK076

Accept



Setup Start



Revision ID:

Item Name: D2891-1 TURNING DETAIL

Stop



Start Date: 2/10/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 2/23/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: \_\_\_\_\_ Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

Packaging

Identify and Stock in Kanban

Location: C.N.C

SF 10/02/22

10 / p

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/23 JJ

MF  
10-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, February 09, 2010 11:41:17 AM

Page 1

Work Order ID: 56038



Parent Item: DSK076



Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 2/10/2010

Required Date: 2/23/2010

Comments: IPP rev A. 08.03.13 new issue EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6104-003		Manufactured		No			Each	20.0000	10.0000			

Round Billet, 17-4



Warehouse                    Loc Qty                    Loc Code

Location

Main Warehouse

MAT

20

53750

20

10                    SL                    10/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	5603d
Description: Turning Detail for D2891-1	Part Number:	DSK076
Inspection Dwg: DSK076      Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article     Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.2765	2.276	2.277	2.276	2.2755
B	3.702	3.722		3.711	3.714	3.711	3.712	3.715
C	2.564	2.584		2.575	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.475	2.474	2.474	2.474	2.474
G	2.029	2.049		2.038	2.038	2.038	2.038	2.038
H	2.964	2.984		2.975	2.974	2.974	2.974	2.974
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.099	.099	.098	.099	.100
L								
M								
N								
O								
P								

Measured by: SL

Date: 10/02/22

Audited by: SP

Date: 10/02/22

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM <u>SP</u>	<u>SL</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	5603d
Description: Turning Detail for D2891-1	Part Number:	DSK076
Inspection Dwg: DSK076 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article     Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	27	38	49	510
Lathe Section								
A	2.274	2.279		2.274	2.277	2.277	2.2775	2.277
B	3.702	3.722		3.713	3.713	3.715	3.711	3.713
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.038	2.038	2.038	2.038	2.038
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110						
L								
M								
N								
O								
P								

Measured by: SL Date: 10/02/22

Audited by: SP Date: 10/02/22

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM <u>SP</u>	<u>SL</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

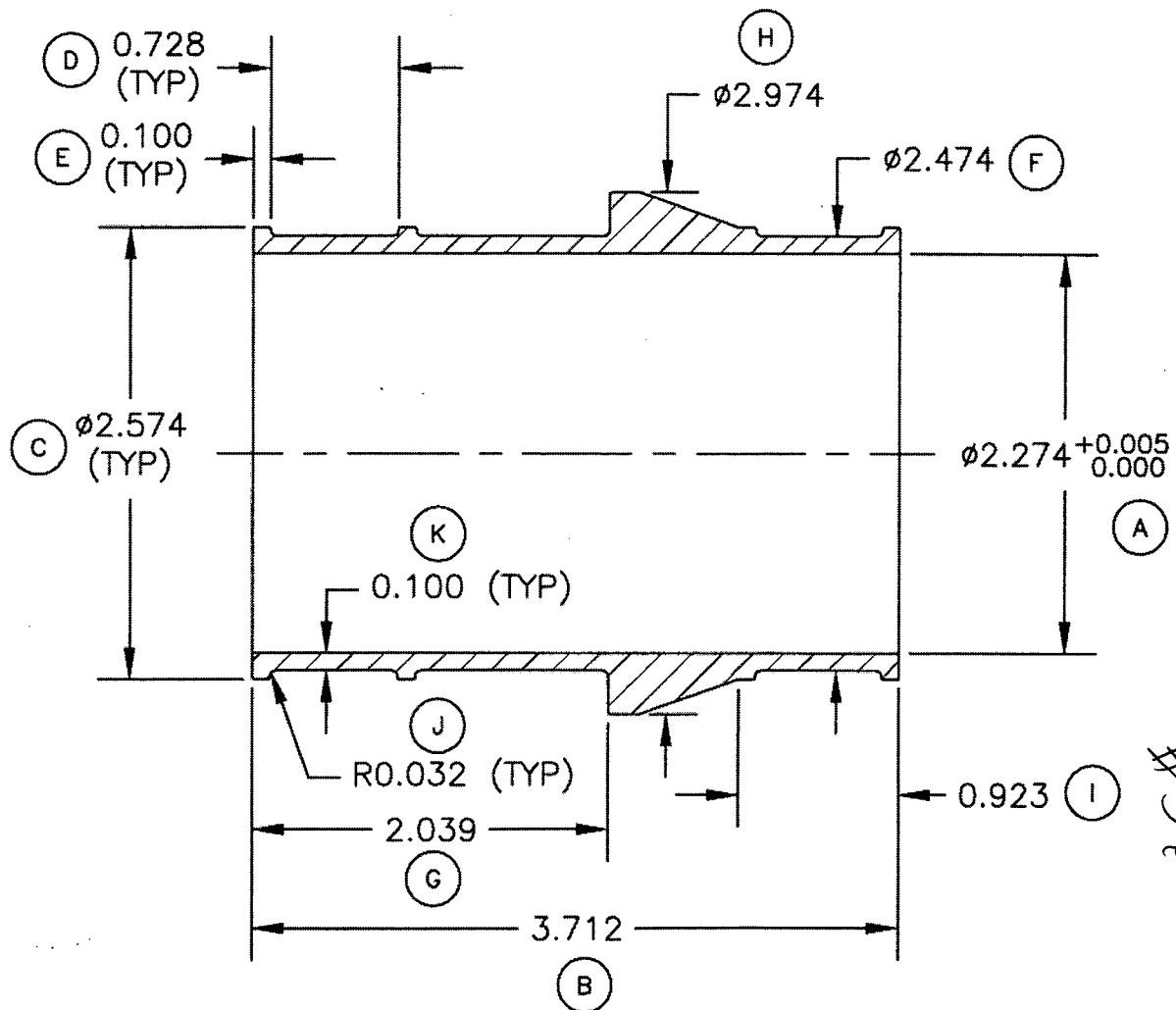
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

**RELEASED**  
03.07.01 *CH*D2891-1 TURNING DETAIL

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3-760

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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